

Date: Wednesday, 4/19/2006 7:42:22 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 26719A	Part Number	: D2221		
Estimate Number	: 10189	Drawing Number	: D2221/D2235		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 4/19/2006	S.O. No.	: N/A		
Prsh Rev.	: NC	Drawing Revision	: F/B1		
First Issue	: N/A	Material	: N/A		
Previous Run	: 26718A	Due Date	: 4/30/2006	Qty:	1 Um: Each
Written By	<u>SEE COMMENT Below</u>				
Checked & Approved By	<u>SEE ABOVE USER & DATE</u>				
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number Description Batch		
	4 D3166-1 RIB <u>B26259</u>		<u>CPL 06-04-19</u>
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number Description Batch		
	2 D2232-3 Hinge bracket <u>B25239</u>		<u>CPL 06-04-26</u>
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number Description Batch		
	4 D2325 Support Gusset <u>B25687</u>		<u>CPL 06-04-26</u>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number Description Batch		
	2 D2327-3 Bushing <u>B25823</u>		<u>CPL 06-04-20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	326204

CPL 06.04.28

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3442-1	Shim	323544

CPL 06.04.26

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty	Part Number	Description	Batch
36 sf	M304EX0.75-16F	Expanded Metal	M100722

CPL 06.04.25

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M100704 → 336.01"

CPL 06.04.19

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

CPL 06.04.27

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/05/03
 QA: N/C Closed: _____ Date: _____

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Seq. #: Machine Or Operation:

Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

1104127

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 04/04/28 (1)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M16048

Expiry date: 11/2006

SAD 06:05:01 (1)

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/03 (1)

Job Completion



06-05-03

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